

IMCY1 – S150

3 or 4 Side Seal Honey packaging Machine



Manual

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- Electrical drawing
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- Equipment list
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Chapter 1: Application

The IMCY – 1S150 3 or 4 side seal honey packaging machine is suitable for packing sticky flowing liquid with wiredrawing phenomenon, such as balsam, honey, shampoo, butter and so on.

Chapter 2: Packing material

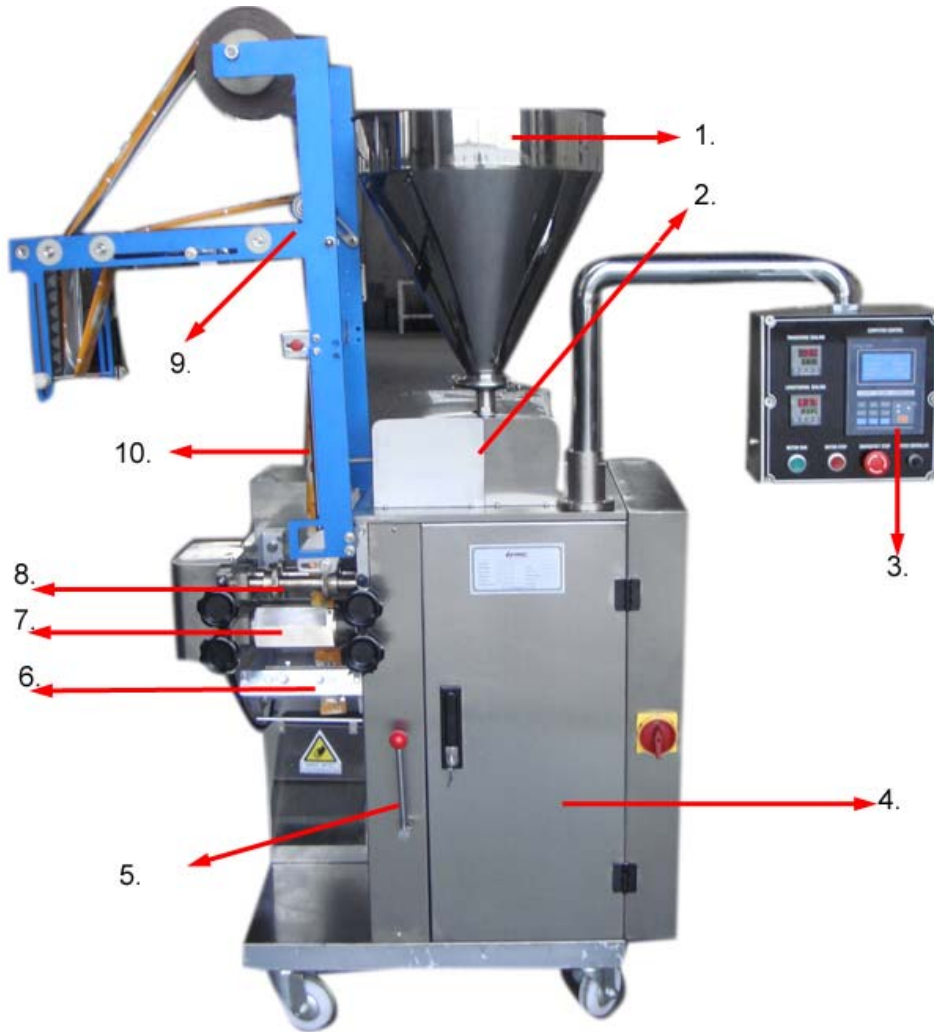
The packing material takes heat-seal lamination, Paper/PE, the lamination that the surface is PET, and its form must be in rolls, the outside diameter should below 300mm and the inner diameter is 75mm.

Chapter 3: Main Technical Parameter

Capacity:	30-75bags/min
Filling range:	30-150ml
Bag size:	Max (W*L) 80mm*110mm
Heater:	110v, 250w*4
Total power consumption:	1.4kw
Weight:	About 400kg
Dimension (L*W*H):	1000mm*1050mm*1850mm
Main Motor:	220v, 750w, 1440 r/min

Chapter 4: Sketch of operation parts

The marks in the figure are named as follows:



1	Machine hopper	2	Gear pump
3	Controller	4	Machine house
5	Cutter clutch	6	Cutter
7	Horizontal sealing	8	Vertical sealing
9	Film brace	10	Film mould

Chapter 5: ATM-19E Controller User Manual

ATM-19 Packer Continue Feeding Controller is a multi-function digital controller designed for the automatic packing machines. It can be installed on most of the automatic packing machines in the market. ATM-19 use liquid crystal display technology. ATM-19 has tracking function. The length scope is from 1 to 999mm. The counting scope is from 0 to 99999.

ATM-19 has the following:

5.1. Keyboard and operation Key

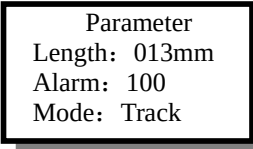
ATM-19 has liquid crystal screen and operation keys.

The size of installation is 144 by 118 mm².

The size of outer shape is 150 by 124 mm².

Operation keys:

- SET: Set up the parameter
- HELP: Show the help message.
- ENTER: Confirm and save the parameters
- (▲): Increase the parameter
- (▼) : Decrease the parameter
- (◀): Set up the one flashing digit
- CLEAR: Clear the count
- DISPLAY: Display the parameter
- SURVEY: Survey the length
- JOG: Manual feeding

A rectangular LCD display with a black border showing parameter settings.

Parameter
Length: 013mm
Alarm: 100
Mode: Track

(fig 1)

5.2. Functions and operation directions

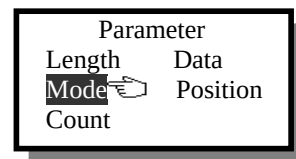
With power on, the main motor is stopping and the system is waiting.

The liquid crystal screen will show see (fig 1).

If the parameter is correct the main motor will startup.

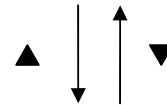
a) Set up the functions

After pressing the SET key, the screen will show five parameters, see (fig 2). When pressing the (◀) key, the digit flashes among five parameters. When pressing the ENTER key, set up the flashing digit. Take the length of the bag for example this is how we will introduce the way to set up the parameter.

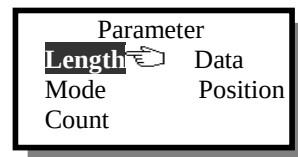


b) Setting-up the bag length

When the pointer is pointing to the length of the bag, set up by pressing the ENTER key (fig 3).



The digit will be flashing and can be modified by pressing the (▲/▼) key.



Press the (▲) key to increase the flashing digit. Press the (▼) key to decrease the flashing digit. Press the ENTER key to save the changes. The changes will not be lost before set up the parameter again.

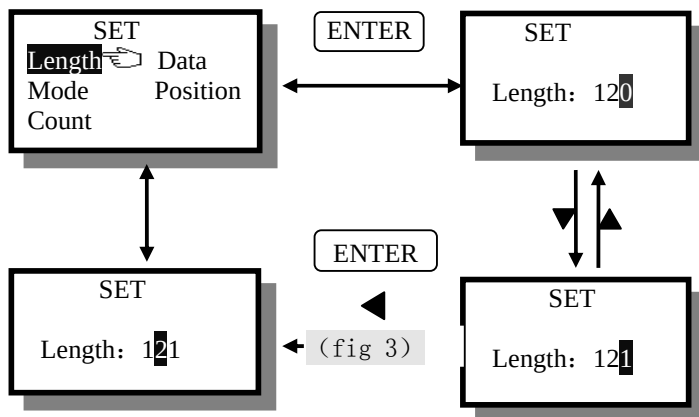
(fig 2)

Note:

Be sure to adjust the end and then boot.

c) Set up the counter

An alarm can be set up to remind operators to collect the bags into a large package (for example, 100 bags per package). ATM-19 will start alarming when it's processing the 5th last bag, starting with the short alarm tone and ending with the long alarm tone. Meanwhile, ATM-19 can send out a switch signal to other devices in accordance with user's needs.



To change this parameter, use the SET and ENTER key as the same way as setting up the bag length in the above sections.

d) The cutting knife position setting

To change this parameter, use the SET and ENTER key in the same way as setting up the bag length in the above sections.

During the production, we will modify the cutting parameter so that we can modify the distance between cutting knife position and color mark.

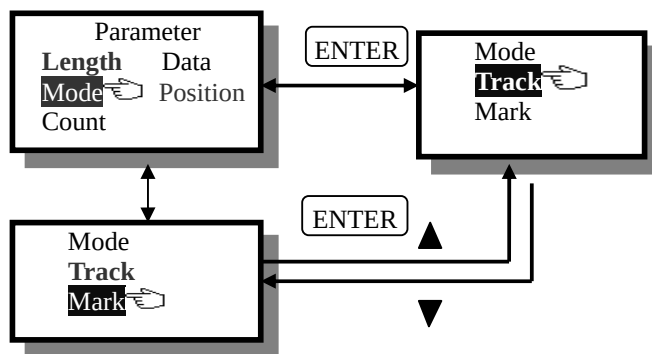
e) Set up the data

To change this data, use the SET and ENTER key in the same way as setting up the bag length in the above sections.

When selecting the data and pressing ENTER key, then the liquid crystal screen will show “please enter the code...”

The girth has been pre-set by the manufacturer and cannot be changed by users.

f) Set up the mode



(fig 4)



To set up the mode see (fig 4).

To change this parameter, use the SET and ENTER key in the same way as setting up the bag length in the above sections.

5.3. DISPLAY key

After pressing the DISPLAY key, switch among the work parameter, the running parameter and company name. The working parameter will show three primary parameters. Running this interface will show the packing quantity, packing speed, cutting knife position and the working mode.

5.4. JOG key

The feeding motor will start feeding at 2M/min speed when the JOG key is pressed and held. The motor will stop when the JOG key is released.

5.5. HELP key

Pressing the HELP key will give you a help message.

5.6. ENTER key

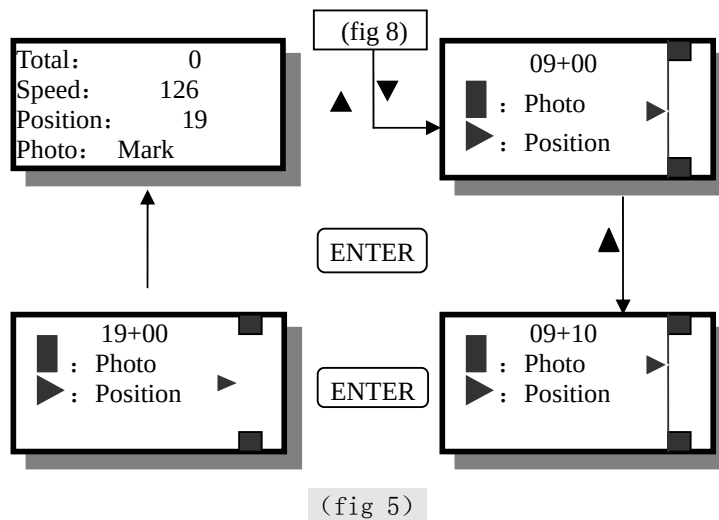
After pressing the ENTER key, confirms and saves your parameter setting. At the same time, liquid crystal screen returns to the front interface.

5.7. CLEAR key

To clear the counter, press the CLEAR key and starts counting again.

5.8. ▲▼Key

Press the ▲ key to increase the flashing digit. Press the ▼ key to decrease the flashing digit see (fig 5).



5.9. SURVEY key

After pressing the SURVEY key, liquid crystal

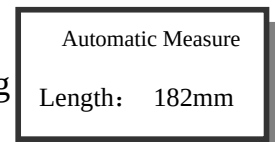
Screen show survey (fig 6).



(fig 6)

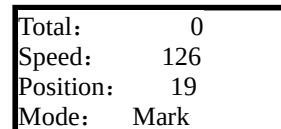
When the system start up, feeding motor begin to feed. After finding the photo mark at the first time, system begins to survey see (fig 7). When finding the photo mark the second time, system stops surveying and show the surveyed results.

Then it will modified the length of the bag according to the surveyed length automatically and return to the waiting interface.



(fig 7)

After startup the system, liquid crystal screen will show the interface see (fig 1), the controller will enter the waiting state.



(fig 8)

At first, according to the photo mark length of the packing paper it will set up the running parameter and will be ready.

At that time, you'd better select the automating surveying function.

After surveying the length of the bag exactly, power on the main motor, then, the liquid crystal screen shown in (fig 8), the feeding motor will track the mark to feed according to the selected cutting knife position, the cutting knife proper position.

At the time, liquid crystal screen show packing quantity, including total number, packing speed (unit/minute).

ATM-19 has intelligent characteristic during the running process, pressing ▲▼ key may modify the cutting knife position at any moment the controller does not need adjust the position of the photo electricity.

After the mainframe has stopped, the system will be at a waiting state. The liquid crystal screen shown in (fig1).

Chapter 6: Notice

- a) Avoid touching the liquid crystal screen by something sharp lest the liquid crystal be damaged permanently.
- b) When system powers off, wait for 10 minutes. Then power on the main motor, or else the system will work abnormally. The distance between the gear sensor and the gear should be 0.5 – 1.5mm.

Chapter 7: How to operate and adjust the machine

7.1. Temperature

Turn on the power switch, set the temperature of longitudinal sealing roller and cross sealing roller between 110°C-130°C. (Usually, for three sides sealing bag or pillow shape bag, the temperature of cross sealing roller should be 10-20°C higher than longitudinal sealing roller. But for four sides sealing bag, the temperature of longitudinal sealing roller should be 10-20°C higher than cross sealing roller.)

7.2. Revise the temperature

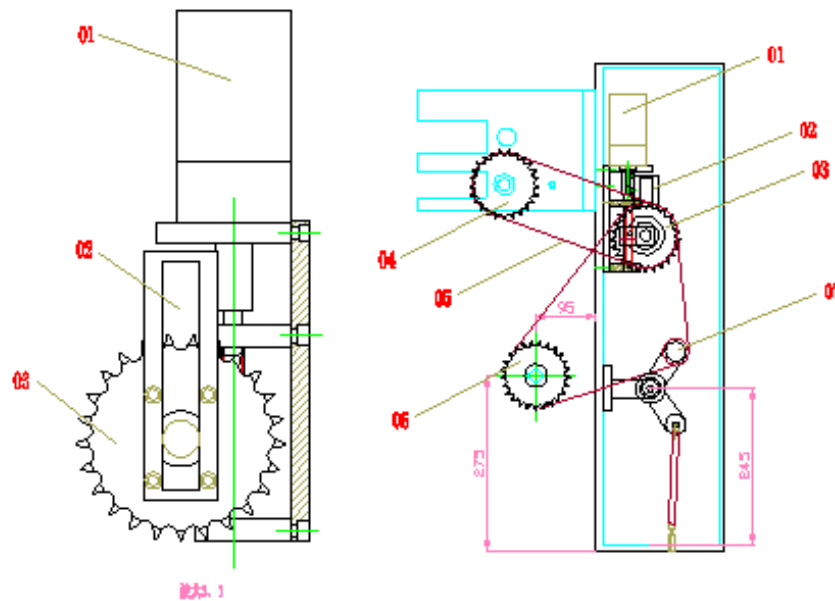
To revise the temperature: Press <AT> key for more than 10 seconds till the light of <AT> key glitters. In the period of the light glittering, it is forbidden to stop the machine or revise the temperature again.

7.3. Adjust the bag size

- a) Choose “Mode” on computer control, then “Track”.
- b) Under “Track”, set the length needed.

7.4. Wheel angle adjustment

When the cross-sealing is parallel, the guide rod 02 and the motor 01 at the level of state (see diagram below). Adjustment method: When the cross-sealing is parallel, open the chain 05, with your right – hand turn guide bar sprocket 03 so that the guide rod 02 and motor 01 is at a level of state, and then connected to the chain 05.



01	Electrical	05	Sprocket chain A
02	Rod	06	Spindle sprocket
03	Rod sprocket	07	Tensioned pulley
04	Horizontal sealing sprocket		

Note: The agency perspective of the factory has been fine, do not adjust it.

7.5. Setting mark-track

a) Choose the “Mode” key, then change it to “mark” key, make the indicator on the photoelectric probe aim at the center of the mark, then you can operate the machine. When the cross sealing roller is not press in the correct position, above the mark or below the mark, you can choose “△” and “▽” on the computer to adjust the figure and then choose the “Enter” key.

b) Please notice and make sure there is no other color between the two marks, or the photoelectric probe will mistake an action.

c) Adjust the sensitivity knob on the photoelectric probe, make sure the indicator light glint one time only when the marks pass the photoelectric.

- d) Check whether the color of the mark is similar to the color of the film, if they are similar, the photoelectric probe will not work well.
- The more of a difference the better (for example, the film is black, the mark is white or the film is white, the mark is black).

7.6. Inspect the color by switch chart

This chart shows you how to inspect the color by switch.

Green Light										
	Black	Silver	Red	Orange	Yellow	Green	Blue	Indigo	Purple	White
Black	—	○	×	○	○	×	×	×	○	○
Silver	○	—	×	×	×	○	○	○	○	×
Red	×	○	—	×	×	×	×	×	×	○
Orange	○	×	×	—	×	○	○	○	×	○
Yellow	○	×	×	×	—	○	○	○	×	×
Green	×	○	×	○	○	—	×	×	×	○
Blue	×	○	×	○	○	×	—	×	×	○
Indigo	×	○	×	○	○	×	×	—	×	○
Purple	○	○	×	×	×	×	×	×	—	○
White	○	×	○	○	×	○	○	○	○	—

Chart 1

Red Light										
	Black	Silver	Red	Orange	Yellow	Green	Blue	Indigo	Purple	White
Black	—	○	○	○	○	×	×	×	○	○
Silver	○	—	×	×	×	○	○	○	×	×
Red	○	×	—	×	×	○	○	○	×	×
Orange	○	×	×	—	×	○	○	○	×	×
Yellow	○	×	×	×	—	○	○	○	×	×
Green	×	○	○	○	○	—	×	×	○	○
Blue	×	○	○	○	○	×	—	×	○	○
Indigo	×	○	○	○	○	×	×	—	○	○
Purple	○	×	×	×	×	○	○	○	—	○
White	○	×	×	×	×	○	○	○	○	—

Chart 2

Blue Light										
	Black	Silver	Red	Orange	Yellow	Green	Blue	Indigo	Purple	White
Black	—	○	○	○	○	×	○	×	○	○
Silver	○	—	×	×	×	○	○	○	×	×
Red	×	○	—	×	×	○	○	○	×	×
Orange	×	○	×	—	×	○	○	○	×	×
Yellow	○	○	×	×	—	○	○	○	×	○
Green	×	○	○	×	×	—	×	×	○	○
Blue	○	×	○	○	×	○	—	×	○	○
Indigo	○	×	○	○	○	×	○	—	○	○
Purple	×	○	×	×	×	×	○	○	—	○
White	○	×	○	○	○	○	○	○	○	—

Chart 3

Notes:

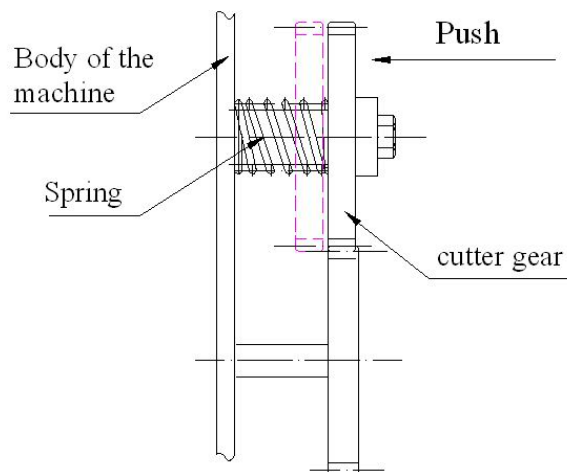
“○”means it easy to inspect,

“×

“—”means it cannot be inspect.

7.7. Setting the knife

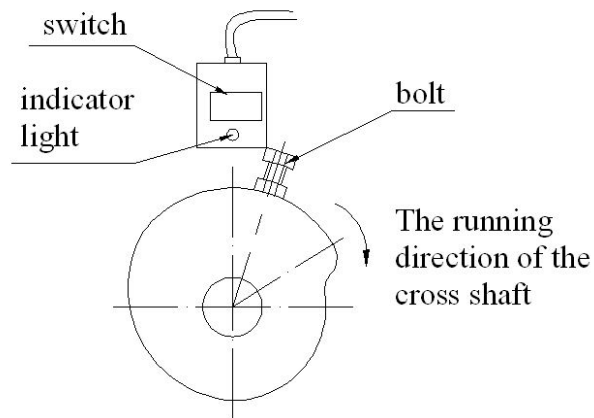
Don't set the knife until the cutter clutch is closed. Measure: when the machine has stopped, push the cutter gear wheel inside, move it away from joggle gear, run the gear forward or backwards, then loose the gear. (Please refer to schematic chart 2.)



Schematic chart 2

7.8. Setting the position of the feeding material

When the cross sealing rollers are parallel, turn the cam wheel on the shaft, make the bolt on the shaft just pass the feeding switch. (Please refer to schematic chart 5.)



Schematic chart 5

7.9. Processes of running and stopping the machine

Steps of operating:

- a) Lubricate the following parts with oil. Slipping parts of feeding, cutter clutches, copper and alloyed turning parts, and relative moving parts.
- b) Check if the cutter and feeding clutch were opened.
- c) Power on, the indicator light will show that the power is on the machine. Also the indicators of the longitudinal and horizontal sealing heaters turn on.

- d) Change the temperatures of the longitudinal and horizontal controllers to what you want it to run as. It's depends on the different packing materials. Usually it is between 100° and 250°. Additionally the temperatures for the longitudinal sealing element are different from the horizontal sealing elements. This is depending on actual status.
- e) Fit on the packing film.
- f) Pull the film to the longitudinal rollers and aligned to them.
- g) Bag making on track condition. The error between the completed bag and real bag (length between centers of the two photo marks) is less than one millimeter.
- h) After bag making is complete, press Mode change Track to Mark.
- i) Switch on the cutter clutch, check if the cut position is correct.
Turn off the motor to adjust.
- j) Feeding.
- k) When the above steps are done, the machine is ready to produce.
Once powered is on and have connect the clutches.

Chapter 8: Steps for stopping the machine

- a) Press Stop on key R/S, which will stop the feeding.
- b) Turn off the cutter clutch.
- c) Turn off motor switch.
- d) Turn off power.
- e) Check and clean, etc.

Chapter 9: Matters that requires your attention.

- a) Pay attention to the machine sound, and distinguish the abnormal running sound.
- b) Clean adhesion PE on longitudinal and horizontal rollers with cooper brush, as the adhesion would destroy the heat sealing view and weaken the drawing force of longitudinal sealing.
- c) Check and clean when the power is off.
- d) When cutters are running, people and others things are forbidden to be near them. Especially when hands have to enter them the machine must be powered off.
- e) Check each fastening pieces timely, to avoid loosening.

- f) The reducer should be oiled 10 days after it is first used. Later exchange new oil each 2000 hours and the amount is up to the center of oil leveler.

Chapter 10: Transportation and installing

This machine can be on the casters down when moving. The ground must be flat, or the casters will break. With long term transportation, a reliable packing case is needed. The machine is fixed on the baseboard of case by four supporting feet. The upper has to be fixed by supporting plates; a cushion should be between the contact parts. The case needs to be marked with “KEEP UPRIGHT, NOT TO BE TRIED and NO STRIKE” these words must be seen on the outer case of the packing case.

Chapter 11: Troubleshooting and there solutions

11.1 When some parts refuse to start up.

Reasons:

- a) Fuse blown. Proper ampere fuse should be renewed.
- b) Wring of the motor is broken. Connect again.
- c) Electromotor is bad. New one is needed.
- d) Bolts of some of the connecting gears are slap loose. Fasten them up.
- e) Something is in the gears or other drive parts, at this moment the motor would sound abnormally. Take them out.
- f) Another object has entered into the cutter and the two blade edges fit too tightly take out the objects and adjust the distance of the two blades.

11.2. Transverse sealing roller cannot rotate

Reasons:

Bearing of the heat sealing roller has not been filled with oil in time, and the bearing bush is dead, change with a new bearing bush.

11.3. The malfunction of the material feeding part

The packed product is inserted into the part of the transverse sealing.

Reason:

The time of the feeding product and sealing time of the transverse sealing are not in accordant; you should adjust the material feeding time.

11.4. The malfunction of the cutter

The cutter cannot cut off the film.

Reasons:

- a) The gap between the rotating cutter and fixed cutter is not adjusted well.

Adjusting method: the gap of the two blade edges is 0.01mm for the best results.

- b) The blade edge of the cutter is worn. If the worn part is small, grind the cutter by oilstone, and if big, repair it by grinding machine.

- c) There is a malfunction of the heat sealing rollers

11.5. The sealing is not good.

Reasons:

The temperature of the heat sealing has not been adjusted properly, pressure of the push spring is not enough or uneven. Method: according to the thickness and category of the used packing material, choose the correct temperature to do the heat sealing. If the sealing temperature is too low, the sealing part is easy to peel. The pressure of the heat sealing rollers is adjusted by the push spring; it needs proper temperature and pressure for the heat sealing rollers to achieve a good seal.

11.6. The malfunction of the electrical system

a) The current of the heat sealer is too large or the fuse has blown.

Reasons: there is short circuit in the electric heater or heat sealing circuit.

b) The heat sealing roller is not hot. Reasons:

(1) The heating wire is burnt out.

(2) The fuse of the heat sealing has blown.

(3) Electric relay problems

(4) Temperature controller problems

c) The temperature of the heat sealing roller cannot be auto-control (temperature is too high). Reasons:

(1) The circuit of the thermo scope is not free or the thermo scope of the longitudinal sealing and longitudinal sealing roller cannot make good contact.

(2) There is malfunction in the temperature controller.

(3) The temperature controller has not been corrected.

Chapter 12: Mechanism Adjustment and Troubleshooting

12.1. How to adjust if the temperature controller is showing a large difference in temperature?

Answer: Press the <AT> key on the temperature controller more than 10 seconds till the <AT> indicator light turns on. The temperature controller will correct it by itself; the normal difference in temperature is within 2°C.

12.2. How to adjust it if the speed for making bags is sometimes higher and sometimes lower?

Answer:

- a) The reason is the length we set is far different as the actual distance between the two marks. We should make the tolerance within $\pm 1\text{mm}$.
- b) The sensitivity we set on the photoelectric probe is too high, so this problem will happen. The best way for setting sensitivity is: setting a lower sensitivity, turn the knob left till the indicator light is on, then setting a higher sensitivity very slowly, turn the knob right, and stop it immediately as soon as the indicator light glints. This will be the best way to set the sensitivity.
- c) While making the bags, photoelectric probe meets other colors on the film.
- d) When the cross sealing rollers parallel, to the wheel length is not at a 45° angle.

12.3. What to do if the sides of the bags made by the running machine are not symmetrical?

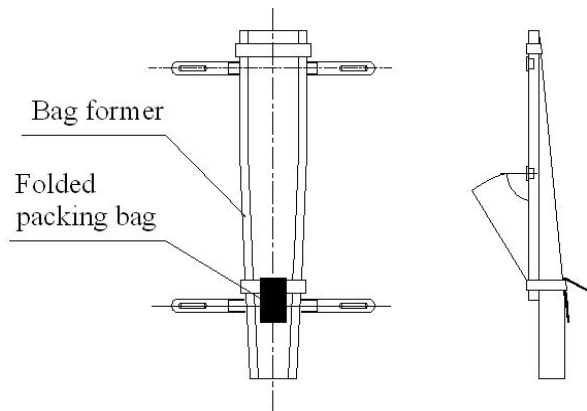
Answer:

- a) Adjust the bag former, make the midline of the bag former and the midline of the film, cross sealing roller and longitudinal sealing roller on one line. Measure: Loosen the four snails on the bag former, hold the bag former by one hand, another hand knocks the bag former lightly to make the bag former move to the unsymmetrical side.
- b) Adjust the stand of the bag former fore-and-after; make it vertical with the electricity box. Measure: Loose the up and down snails, move the stand to the side face where the paper comes out from.
- c) Inspect whether the two sides of the film are symmetrical, when the film is running out at the bottom of the bag former. Measure: If you find the coming out film in one side is less than the other side at the bottom of the bag former, you can prize the lesser side by using a screwdriver very lightly.
- d) Inspect whether the hoop on the bottom of the bag former is too loose?

Measure:

(1) Insert one empty bag into the space between the hoop and the packing material; make the packing material cling to the bag former.

(Please refer to the chart 6.)



Schematic chart 6

(2) Make one end of the hoop open; insert the film, set a good clearance, then weld the hoop again.

12.4. What to do if there is always material in the sealing area of the bag while the machine is running?

Answer: Setting the time of the feeding material: It will be ok if there is no material when the cross roller works.

12.5. What to do if the bags are always declining, not rectangular?

Answer: Setting the stand of the bag former, make it vertical with the cross sealing roller. Measure: Loosen the two snails on the stand and move it forwards or backwards.

12.6. The machine I bought is four sides seal packing machine, why does the sides of the bags are always asymmetry and coming out?

Answer: The main principle of setting four sides seal machine is to balance the pressure of the two longitudinal sealing rollers.

Measure: Set the pressure of the longitudinal sealing roller to zero, then increase the pressure from the two sides, keeping the pressure balanceable. When the impression of the bag becomes clearly, stop increasing the pressure, then fix the snails to prevent loosing. If necessary, you can increase the temperature.

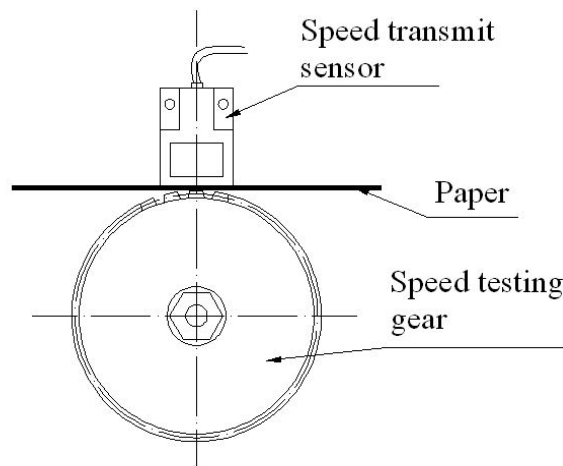
12.7. When you start the machine, why doesn't the longitudinal sealing roller run?

Answer:

a) The pressure of the longitudinal sealing roller is too big, reducing it will be OK.

b) The interspaces between the speed testing switch and the speed testing gear are too big. Measure: Loosen the speed testing switch, make the sensor of the switch just on the midline of the speed testing gear. Put a piece of paper on the speed testing gear (Please refer to the chart 7.) Making the switch touch the paper will be OK.

c) Check the vertical and horizontal sealing system bracket: First turn off the power, release the right of the vertical shaft seal bearing the shelves of the two screws, and then slowly tighten by hand while rotating vertical shaft seal, there will be resistance immediately when you stop, if a little loose open the screws to the bottom of the mat bearing copper or aluminum, and then spin locking wire, your hands feeling smooth rotating vertical shaft seal quickly, there is no resistance there.



Schematic chart 7

12.8. The cutter of my machine is clamp cutter; sometimes it cannot cut off the film, what's wrong with it?

Answer: The main principle of setting clamp cutter is to control the temperature and balance of the pressure.

Measure:

- a) Increase the temperature of the cross sealing roller properly.
- b) While adjusting the pressure, please notice the balance of the pressure.

c) Because of the cross sealing roller and cutter will transform under the high temperature, we can put some fragment of can (such as Coca Cola can) under the cutter, block up the cutter, the width and length are decided by the dimension of the bag.

d) If the bag is pillow shape, we can adjust the longitudinal sealing area to 5mm, make sure the high quality of superpose of the cross sealing area and longitudinal sealing area.

12.9. What kind of packing film should be used after buying IMC packing machine? How to confirm the bag size?

Answer: Because IMC packing machine adopts continuous sealing that measure the packing material as it is running under high temperature and high pressure. The melting point of outside layer and inside layer of the film should be different and the more the difference the better. It is best if the outside layer doesn't distort when the inside layer seal is strong. If the difference of the two melting point are small, the inside layer cannot be sealed under low temperature or the outside layer will melt under high temperature.

Suggestion 1:

According to the different packing material, the different temperature resistance, oxygen permeability of per square meter in 20 hours is different. We suggest you choose PET as the outside layer.

Suggestion 2:

According to golden section, Galileo's law of falling bodies and the concept of aesthetics, we suggest you keep 1/3 space, 2/3 material when you design the bag, if it is a powder material, please leave more space in the bag.

12.10. How to do it if the finished bag releases gas?

Answer:

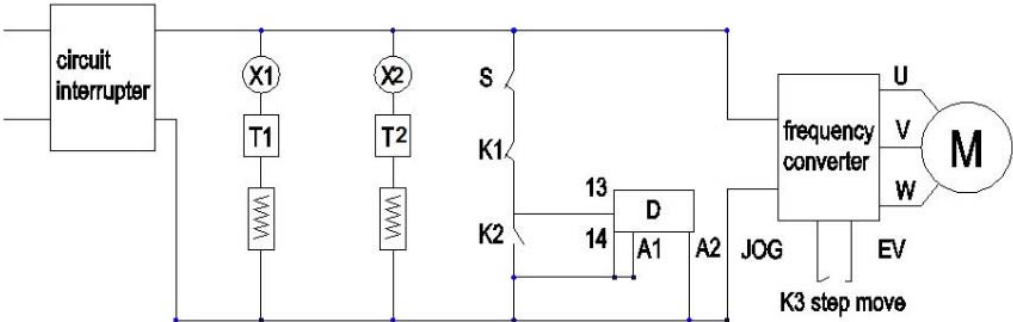
- a) Inspect the film whether the layers are separated?

Measure: Put the film in hand, twine it again and again, inspect if the layers are separated.

- b) Inspect if there are burrs on the sealing roller.

Measure: Burnish the two sides of the sealing roller by sand paper.

Electrical Drawing



	X1	X2	T1	T2	S	K1	K2	M	D
heating rod	vertical sealing heating pilot lamp	horizontal sealing heating pilot lamp	vertical sealing temperature meter	horizontal sealing temperature meter	emergency stop	stop	run	motor	alternating current contactor

Controller ATM- 19E

+ 15V +15V	Connect: speed measuring photoelectric position. Sensor power (+)
Speed measuring	Connect speed measuring signal of sensor
Photoelectric	Connect photo switch signal
Position	Connect position switch signal
IN4	NC
IN5	NC
IN6	NC
IN7	Feed
IN8	Paper
OV OV	Connect: speed measuring, photo, position. Sensor power (-)
+ 24V + 24V	Connect: CP signal common (+)
CP	Connect: stepper motor CP signal
OUT 2	
OUT 3	
OUT 4	
OV OV	

Equipment list

Device No	Original supplier	Description	Model	Usage
1	AiSET	Temperature meter	XMTG1000-2	To measuring the reality temperature of horizontal and vertical sealing
2	HONDON	Micro computer controller	ATM-169E	To adjust packing machine parameter.
3	CNHENW	Photocell	KS-WG22	To track the mark on the packing material
4	SNASDA	Step motor driver	ATMH-4A/12X	To drive packing material working
5	HONDON	Stepping motor		To drive bag making
6	HONDON	Signal switch	GD-TL-Q5MC1	To measuring the count number and photocell
7	TX	Frequency motor	750KW	To drive the machine running
8	HONDON	Measure speed signal switch	ATM-01	To measure the sealing parts speed
9	SNASDA	Eccentricity controller	ATM-PX-A	Adjust the eccentricity automatically

Equipment List Parts

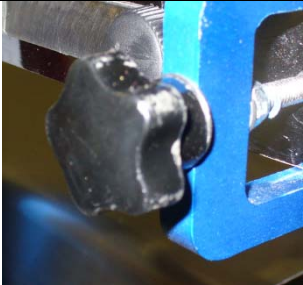
Nos.	Part Name	Photo
1	Temperature meter XMTG1000-2 AISET	
2	Micro computer controller ATM-169E	
3	Photocell KS-WG22 CNHENW	
4	Step motor driver ATMH-4A/12X SNASDA	

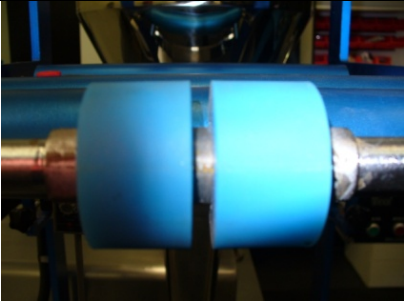
5	Stepping motor	
6	Signal switch GD-TL-Q5MC1	
7	Frequency motor 750KW TX	
8	Measure speed signal switch ATM-01	

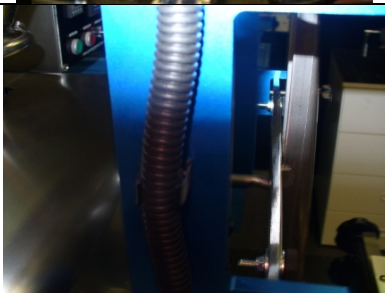
9	Eccentricity controller ATM-PX-A SNASDA	
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Spare Parts List

Nos.	Part Name	Photo	Recommend Quantity
1	Power line		1 PC
2	Heating rod for horizontal sealing		2PCS
3	Heating rod for vertical sealing		2 PCS
4	Heating ring for vertical sealing		2 PCS
5	Brush		1PC

6	Introduction CD		1PC
7	Tooth belt		1PC
8	Screw button		1PC
9	Emergency switch		1PC
10	Running Stop button		1PC
11	Temperature meter		1PC

12	Power button		1PC
13	Wheel		1PC
14	Synthetic glass defender		1PC
15	Screw button		1PC
16	Film drawer		1PC

17	Film roller		1PC
18	Screw button		1PC
19	Film reel balancer		1PC
20	Rubber tube		1PC
21	Feeder hinge		1PC
22	Door hinge		1PC

23	Lock		1PC
24	Cutter activation lever		1PC
25	Speed control pod		1PC

Dimension List

Part Name:	Picture	Diameter
Elements		dia16mm L200mm
Vertical sealing roller		Inner diameter 17mm outer diameter 26mm L270mm Inner diameter 17mm outer diameter 26mm L300mm
Horizontal sealing roller		Inner diameter 18mm outer diameter 25mm L310mm Inner diameter 20mm outer diameter 25mm L260mm
Blade		140mm*65mm*10mm(thinckness)